

Work Order ID 130516

Friday, March 13, 2015 12:56:08 PM

130516

Page 1

Item ID: D4154-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCSDate: 150313

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	E

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: EProg Rev: K

2-Deburr if necessary

(10)

Ø

Jm15-3-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(10)

Ø

Jm15-3-16

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Item ID: D4154-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 12/A001

0.00

150

Packaging

Memo

0.00

Packaging

10 Q 18-3-18

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5 15-3-19mf
15-3-18

Picklist Print

Friday, March 13, 2015 12:56:14 PM

Page 1

Work Order ID: 130516

130516

Parent Item: D4154-1

D4154-1

Parent Item Name: Plate

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	653.2910	4.2697	21			
M304S18GA										**	32	Im 15-3-16	
304/316 .050 Sheet													

Location	Loc Qty	Loc Code
MAT	256	
M131700	256	
MAT020	397.291	
124572	11.334	
125552	18.0487	
M126647	22.014	
M128254	17.4387	
M128435	27	
M128864	31.5964	
M129530	34.6667	
M130345	11.1667	
M130923	75.0424	
M131384	148.9834	

131

131384 -

DART AEROSPACE LTD		Work Order: 130516
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

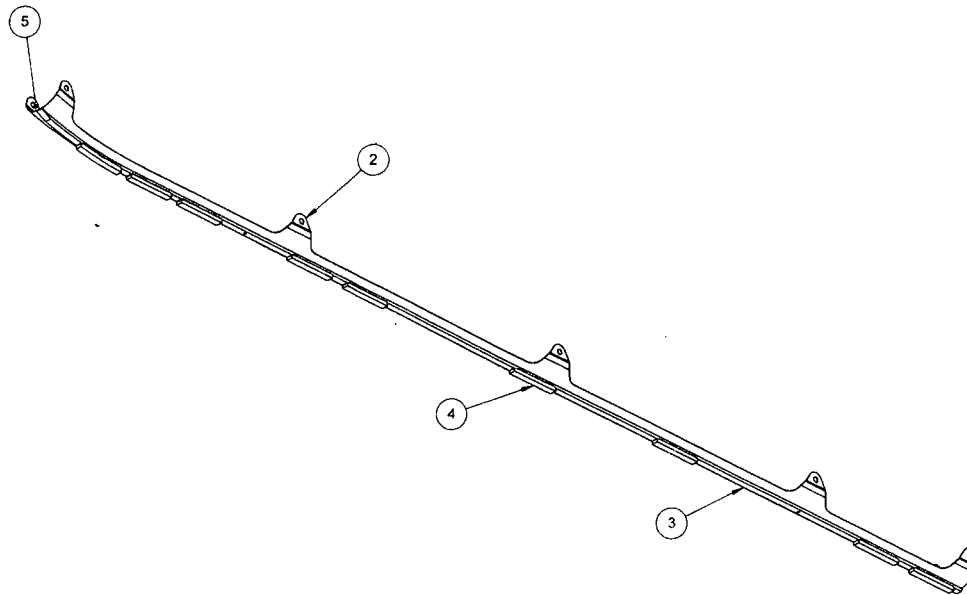
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	0.400"	-		✓	Jkma
0.450	+/-0.010	0.450"	-		✓	
0.125	+/-0.010	0.127"	-		✓	
0.38	+/-0.030	0.38"	-		✓	
0.88	+/-0.030	0.88"	-		✓	
1.19	+/-0.030	1.19"	-		✓	
5.273	+/-0.010	5.273"	-		✓	
6.42	+/-0.030	6.42"	-		✓	
5.223	+/-0.010	5.223"	-		✓	
6.72	+/-0.030	6.72"	-		✓	
40.76	+/-0.030	40.76"	-		T	
15.45	+/-0.030	15.45"	-		T	
66.51	+/-0.030	66.51"	-		T	
70.45	+/-0.030	70.45"	-		T	
90.41	+/-0.030	90.41"	-		T	
91.56	+/-0.030	91.56"	-		T	
0.050	+/-0.010	0.047"	-		✓	
Ø0.516	+0.008/-0.001	0.518"	-		✓	

DAS

Measured by: Jm	Audited by: 9 9-89	Preliminary Approval:
Date: 15-3-16	Date: 15-03-16	Date:

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	
D	12.07.31	Dwg Rev updated	KJ	
E	12.09.26	Dimensions updated per Dwg Rev E	KJ	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)



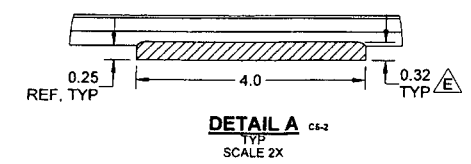
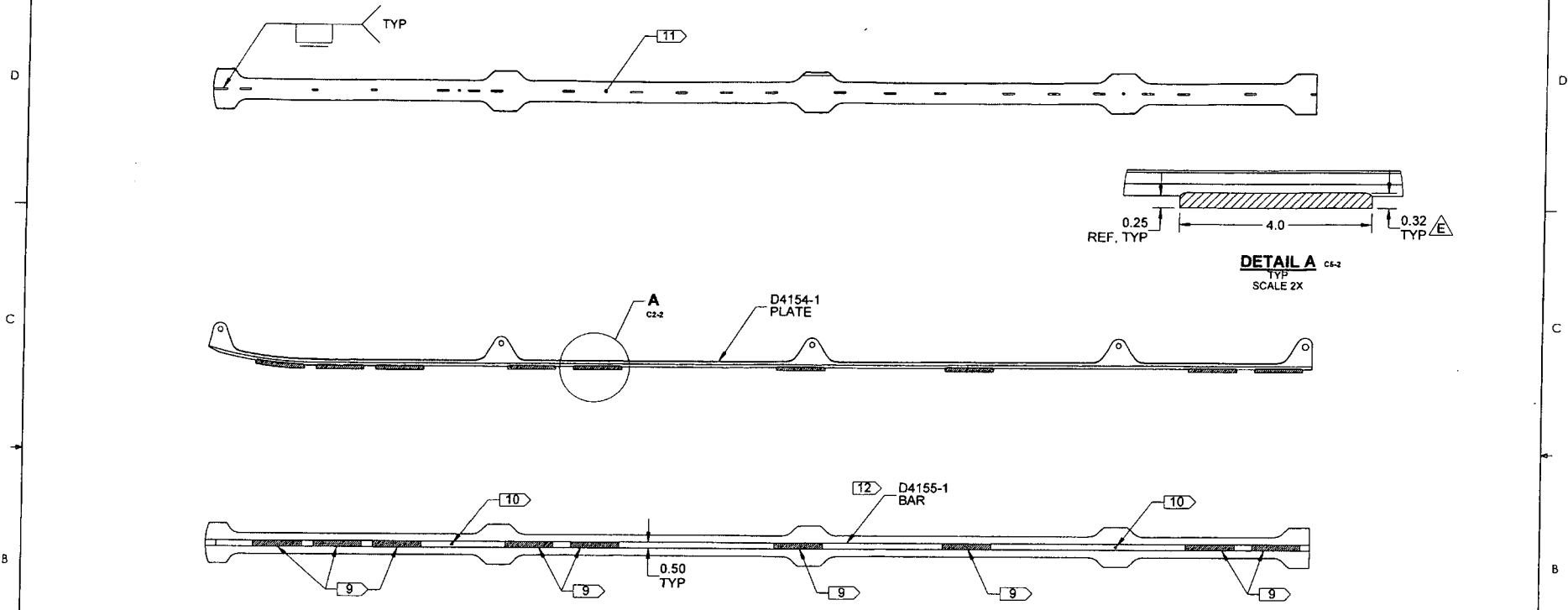
D4154-041 WEARPLATE ASSEMBLY

COPY
 NO. 130516 MW
 1503-13

RELEASED
 2012-09-04

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED	SKP	DRAWING NO.	REV. E
MFG. APPR.	ND	D4154	SHEET 1 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1



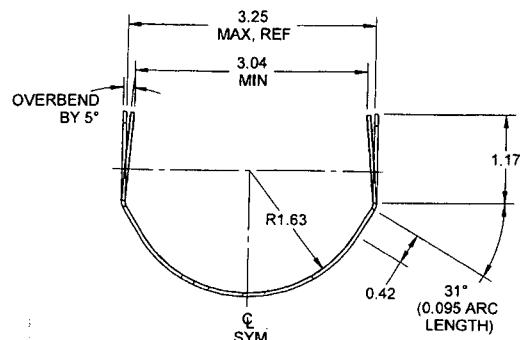
D4154-041 WEARPLATE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 7.75 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
 - 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

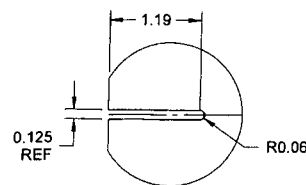
RELEASE
2012-09-04

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DRAWN	AJS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4154	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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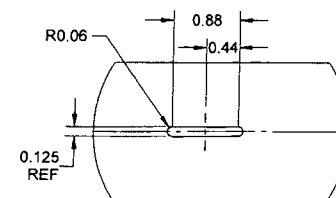
8 7 6 5 4 3 2 1



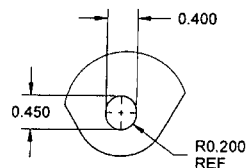
SECTION B-B B3-4
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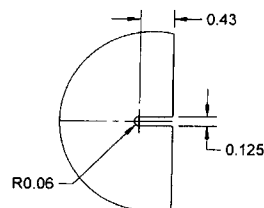
DETAIL C C3-3
END SLOT DETAIL
(SCALE 2.5X)



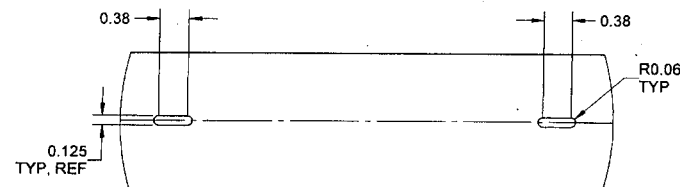
DETAIL D C4-3
SLOT DETAIL TYP
UNLESS OTHERWISE DEFINED
(SCALE 2.5X)



DETAIL E B4-3
SLOT DETAIL TYP
(SCALE 2.5X)



DETAIL F B2-3
END SLOT DETAIL
(SCALE 2.5X)



DETAIL G C7-3
SLOT DETAIL
(SCALE 2.5X)

RELEASED
2012-09-04
JND

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CHECKED		DRAWING NO. D4154	REV. E
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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